Work Order I		15	*110	1698*				Page 1
Revision ID:	536-15 sket Fwd	0 3536-15 B 1 1 0 6 9 8	Accept	*N900	0401	NN*	Setup Star	
Start Date: 1/0 Required Date: 1/0 Reference:	77/14 Start Qty: 6.0 77/14 Req'd Qty: 6.0	• •		Cust Item I Customer:	D:			
Approvals: Pi	rocess Plan:M	Date: 14.01-05	Tooling: SPC (Y/N):		ate:	·	Run Star Stoj	^IVIH I ^
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pl	an Accept ode Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr D3536	Revision Nbr Rev A							
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JE Memo 1-Cut a	T as per Dwg D3536 Dwg Re if necessary	0.00 ev:Prog Rev:	A _2-		/3	0	Jm 14-81-1
110 *110* QC Quality Control	QC2- Inspect parts Memo	off machine FAI/FAIB	0.00			13	٥_	JM14-01-1
120 *1 20* QC Quality Control	QC8- Inspect parts Memo		0.00 DA 2000 294			13		

Quality Control

DQA:			Date:										D	TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:				_			W	ork Order up	odate only		
Work Orde	r.					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS		
WOIR Olde	•					Rework	ıl		Skid-tube Crosstu	be [7	Water Jet	7 F	ngineering
Part N	lo.					Scrap			Machining Small F		- Pro	d. Eng. Coor.	┪╶	Quality
	•				_	Use-as-is			noforming Finishi	_	4	re/Packaging	1	Other
NCR N	lo.	· · · · · · · ·				Suspected Unapproved			Large Fab Compos	ite]	Supplier		
							لے	L			I a: a		_	
Root	ł		c	<u> </u>	Desci	ription of work order update	l	nitial	Action		Sign &	M. 25		061
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design	\dashv		i											
Doc/Data	ᅱ													
Equip/Tooling Handling/Pre	\dashv													
Material												ļ		
Operator														
Offset/Setup							İ							
Process													1	
Supplier														
Training											İ			
Transport				ŀ								·		
Unapproved														
							FAI	ULT CA	TEGORY					
Landi	ng (Sear				General		,		_	7	_		
		Bending				Bend		1	Program		Outside Dim	} -	_	essure/Forced
		Centre No	ot Concer	ntric	ļ	BOM/Route	<u> </u>	Grain			Over/Under	-	_	t-up
		Cracks			\vdash	Broken/Damage/Defect	_	Hardwa		<u> </u>	Part Incorre	<u>-</u>	_	mperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	\vdash	Burrs		4	tion Incomplete/Unqualified	-	Part Lost/Mi	ssing	_\W•	
	-	Cuffs			-	Contamination		4	tions Incomplete/Unclear	<u> </u>	Part Moved	L	JWr	ong Stock Pulled
		Crushing			_	Countersink	-	1	gned/off center	<u> </u>	Positioned V		٦	
		Heat Trea		T I	 	Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge	Ot	ner
		Inspectio	•	iube		Drawing	\vdash	Misrea						
		Marks/Ch			-	Drill Holes	\vdash	Off-set						
	-	Turning S	-		\vdash	Finish		4	Calibration					
I		Wave/Tw	nst in Tuk)e	- 1	Fit/Function	1	Jout of	Sequence					

Work Ord		0698		*11(1698*							Page
Item ID: Revision ID:	D3536-15			Accept	*N900	040	100)*	Setup			S1*
Item Name:	Gasket Fwd									Stop	*N:	S2*
Start Date:	1/07/14	Start Qty: 6.00	*6*		Cust Item I	D:						
Required Dat	e: 1/07/14	Req'd Qty: 6.00	*6*		Customer:							
Reference:			. • • • •									
Approvals:	Process Plan	an:	Date:	Tooling:	D:	ate:		٠	Run	Start	*N	R 1*
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description	/C2 a a l	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
130 *130*		Identify as per dwg & Sto	ock Location 12.00	0.00				X13	d	/	H	14/0

140

QC21- Final Inspection - Work Order Release

0.00

0.00

140

Packaging

Packaging

Memo

Memo

0.00

Quality Control

#14-01-15 #14-01-15

Page 2

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE				A E R O	SPACE
QA Closed:			Date:							1	Wor	k Order up	date only	<u> </u>	
Work Orde	er:					DISPOSITION				AGAINST (DEP/	ARTMENT/	PROCESS		
	•					Rework			Skid-tube	Crosstube			Water Jet	Engineerir	ng
Part I	۱o.					Scrap			Machining	Small Fab		Proc	d. Eng. Coor.	Quali	ty
						Use-as-is		Therr	moforming	Finishing	_	Rec/Stor	e/Packaging	Oth	er
NCR f	No.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		Initial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	QC Inspe	ector
Design															
Doc/Data															:
Equip/Tooling		!													
Handling/Pre							1								
Material															
Operator															
Offset/Setup														ŀ	
Process	L_			;											
Supplier	$ldsymbol{le}}}}}}}$								1						
Training															
Transport	L										1				
Unapproved															
							FA	ULT CA	TEGORY						
Landi		1				General	_			г	_		_	_	
		Bending				Bend		4	Program	1		Outside Dim	├	Pressure/For	·ced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain	•		_	Over/Under	-	Set-up	
	<u> </u>	Cracks				Broken/Damage/Defect		Hardwa			_	art Incorrec	⊢	Temperature	₂/Cure
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs			tion Incomplete/Und	· -	_	art Lost/Mi	ssing	Weld	
		Cuffs				Contamination	\vdash	-	tions Incomplete/U	nclear		art Moved	Ļ	Wrong Stock	Pulled
		Crushing				Countersink	L	-1	gned/off center]		ositioned W		_	
	<u> </u>	Heat Trea			_	Cut Too Short	\vdash	Mislab		Ĺ	F	ower Loss/S	Surge	Other	
	$oxed{oxed}$	Inspection	•	Tube		Drawing		Misrea			_				
	_	Marks/Ch				Drill Holes		Off-set			_				····
	<u></u>	Turning S				Finish	<u></u>	4	Calibration		_				
		Wave/Tw	ist in Tub	е		Fit/Function	<u> </u>	Out of	Sequence						

January-07-14 3:00:58 PM

Work Order ID:

110698

Parent Item:

D3536-15

Parent Item Name:

Gasket Fwd

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	121.4000	0.9848	6:5653332 (&		Juni	4-01-14

DQA:			Date:												957
						WORK ORDER NON	-CC	ONFO	RMANCE / UP	DATE				AEROSPA	A C E
QA Closed:			Date:								Wc	rk Order up	date only		
Work Orde	ar.					DISPOSITION				AGAINST I	DEF	PARTMENT	/PROCESS		
WOIK OIU	•					Rework	1		Skid-tube	Crosstube			Water Jet	Engineering	\neg
Part N	lo.					Scrap	l		Machining	Small Fab		Pro	d. Eng. Coor.	Quality	\dashv
, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	•••					Use-as-is			noforming	Finishing	\dashv		re/Packaging	Other	\dashv
NCR I	lo.					Suspected Unapproved			Large Fab	Composite	\dashv		Supplier	-	\dashv
	•			-		· · · · <u>-</u>	'		• Ш	٠ .					_
Root					Desc	ription of work order update	ı	nitial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspecto	or
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material			·												
Operator															
Offset/Setup							İ								
Process															
Supplier									1						
Training				<u>.</u>											
Transport	-						,								
Unapproved				<u> </u>	<u> </u>		<u> </u>		TECODY						
							FA	ULI CA	TEGORY						
Landi	ng c	Bending				General Bend		الحماني إذ	Program	1		Outside Dim	ansions [Pressure/Forced	ı
	\vdash	Centre No	at Cancar	atric	\vdash	BOM/Route	\vdash	Grain	riografii			Outside Diffi Over/Under	<u> </u>	Set-up	
	\vdash	Cracks	of Concer	itiic	\vdash	Broken/Damage/Defect	\vdash	Hardwa	aro.			Part Incorred	-	Temperature/Cu	ıra
1	\vdash	Crimp/Kir	nk/Binnle	/\\/ava	-	Burrs	\vdash	₹	ion Incomplete/Un	gualified	_	Part Lost/Mi	<u></u>	Weld	n e
	\vdash	Cuffs	IN MPPIE	y wave	-	Contamination	\vdash	1	tions Incomplete/U	· •	-	Part Moved	331118	Wrong Stock Pul	lled
		Crushing				Countersink	-	4	gned/off center	ricical		Positioned V	L Vrong		icu
	\vdash	Heat Trea	at		\vdash	Cut Too Short		Mislab	-	ł		Power Loss/		Other	
		Inspectio		Tube	一	Drawing	H	Misrea		ı		1		1 :	
		Marks/Ch	•			Drill Holes		Off-set							
		Turning S				Finish		4	Calibration						
	Г	Wave/Tw				Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	110698
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15"	_	***	T	Jkmo6
35.65	+/-0.030	35.65	_		+	
33.65	+/-0.030	33.65	_		T	
30.15	+/-0.030	30.15	_		T	
24.90	+/-0.030	24.90m	_		Τ	
19.65	+/-0.030	19.65"	_		Т	
14.40	+/-0.030	14.40			T	
9.15	+/-0.030	9.15"	-		V	Jkmoi
5.65	+/-0.030	5,65"	_		v	
3.90	+/-0.030	3.90"			V	
8.00	+/-0.030	8.00-	_		V	
16.00	+/-0.030	16.004	-		T	
24.00	+/-0.030	24.00"	_		T	
0.30	+/-0.030	0.30°	-		V	
0.30	+/-0.030	0.30"			V	·
1.89	+/-0.030	1.89 "	_		V	
Ø0.19	+0.005/-0.001	0.19"			V	
			DAS			

 Measured by:
 Image: 14.01.14.
 Audited by: 9.89
 Protein

 Date:
 14.01.14.
 Date: 14.1.15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	
Α	07.03.14	New Issue	KJ/JLM 🚓	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\

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2 약 SCALE 1:10

06.10.25

GASKET

07.02.12

39.15 -35.65 33.65 30.15 24.90 -- 19.65 14.40 0.90 - 5.65 1.89 3.90 DETAIL A (TYP 4 PLS) 16.00 24.00

D3536-15 GASKET

32.70 -- 27.25 -21.80 16.35 - 0.90 DETAIL A 10.90 1.89 2.00 - 6.00 8.00 #0.19 (TYP 4 PLS) 16.00 24.00 D3536-21 GASKET

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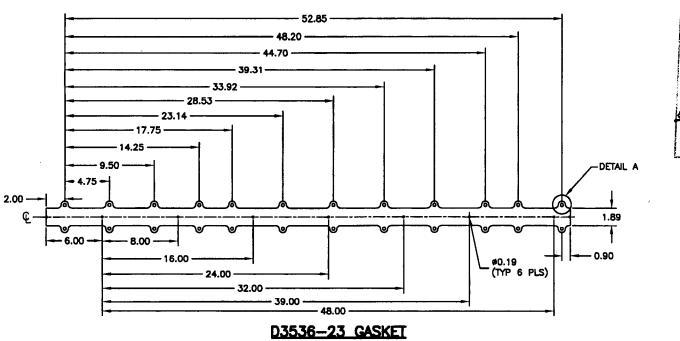
PURPOSE

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COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 2) FINISH: NOTICE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
 2) CEE DADE & CONDETAINS AND SECTION

- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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PURPOSE

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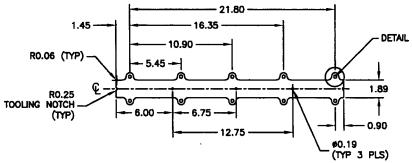
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

2) FINISH: NOTE
3) PART IS SYMMETRICAL ABOUT €
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

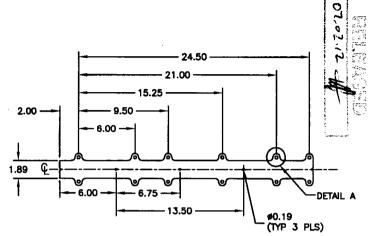
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22.50 -19.00 14.25 2.00 ---9.50 6.00 -1.89 დ-DETAIL A #0.19 (TYP 3 PLS) D3536-31 GASKET



D3536-33 GASKET

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PURPOSE

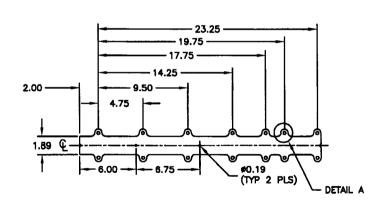
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NOME
 3) PART IS SYMMETRICAL ABOUT
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

•	DRAWN BY	DART AEROSPACE USA, INC.	
	APPROVED //	DRAWING NO. RE	REV. A
7		D3536 SHEET 4 OF 6	6
		आप ९	SCALE
G		GASKET	1:10

06.10.25

GASKET

3

DRAWING NO.

SHEET 6 OF 6

SCALE

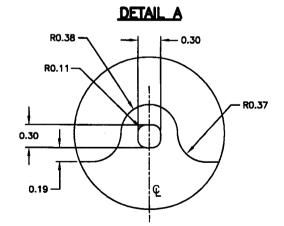
NO.



27.98 25.08 15.00 **8.97** · 2.00 -3.43 1.88 4.00 #0.19 (TYP 2 PLS) DETAIL A

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/18 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE 3) PART IS SYMMI
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER



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